

Fig. 2

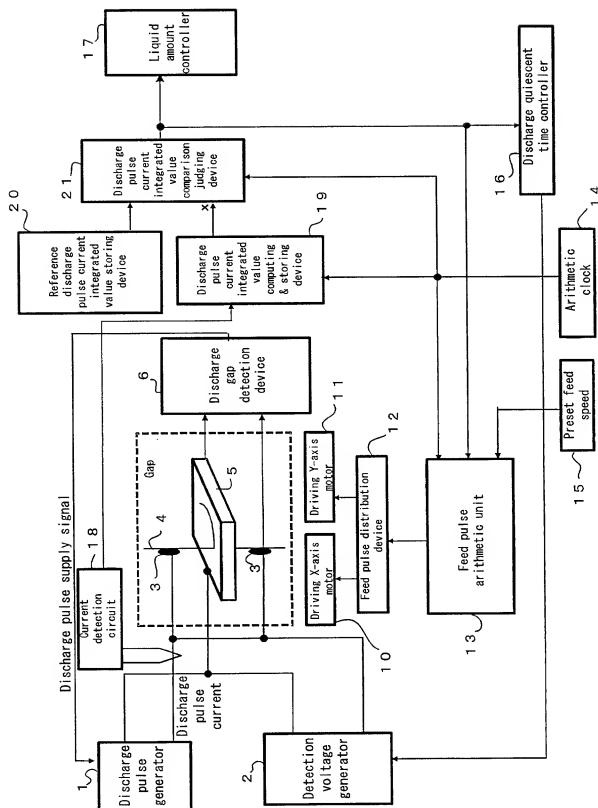


Fig. 3

- P_s : Reference discharge pulse number per unit time T
 P_x : Discharge pulse number per unit time T
 Δ_s : Distance movable with reference speed discharge pulse number P_s
 Δ_x : Distance movable with discharge pulse number P_x per unit time T
 w : Amount of machining per discharge pulse
 t : Plate thickness
 g : Machining groove width
 $P_s * w = \Delta_s * t * g$
 $P_x * w = \Delta_x * t * g$

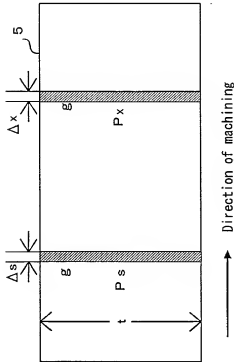


Fig. 4

SPD : Preset feed speed which is used as a reference
 Δs : Distance movable per unit time T
 given by the preset feed speed SPD which is
 used as reference, $\Delta s = SPD * T$
 P_s : Reference discharge pulse number
 P_x : Discharge pulse number per unit time T
 Δx : Distance movable with discharge pulse number
 P_x per unit time T
 $\Delta x = \Delta s * \Delta x / P_s$
 $= SPD * T * (P_x / P_s)$

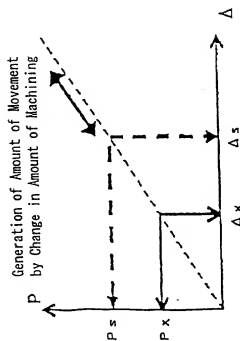


Fig. 5A

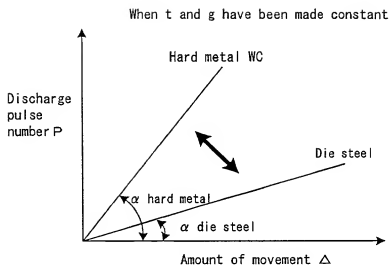


Fig. 5B

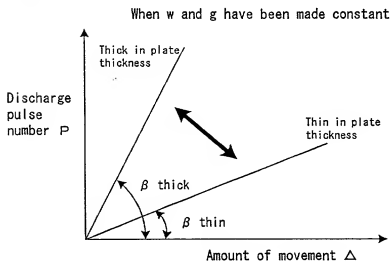


Fig. 5C

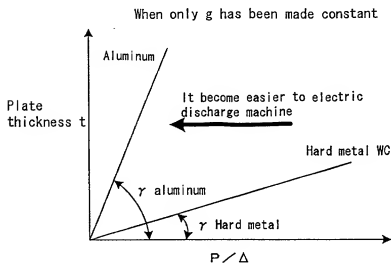


Fig. 6A

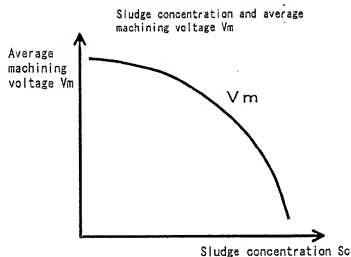


Fig. 6B

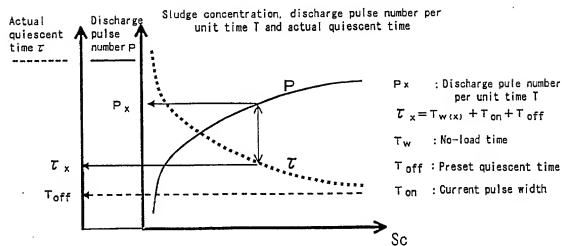


Fig. 7A

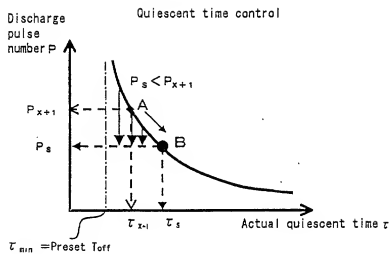


Fig. 7B

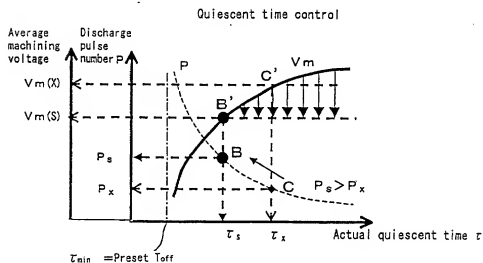


Fig. 8

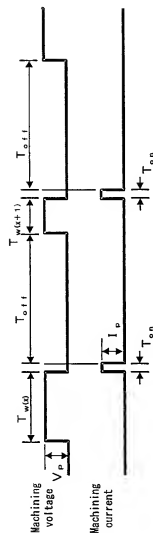
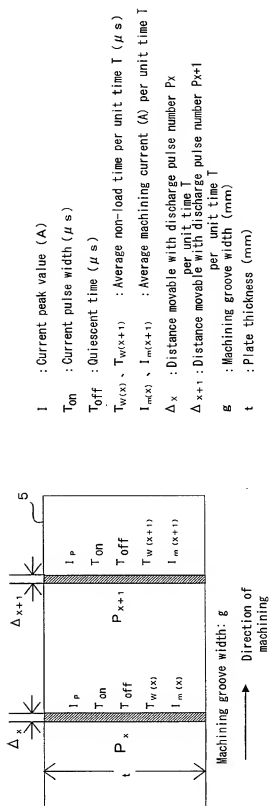


Fig. 9

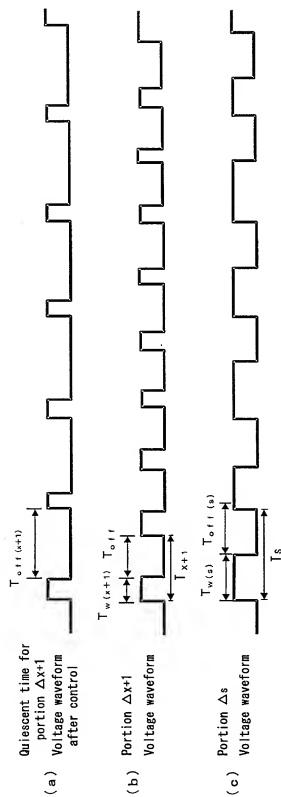


Fig. 10

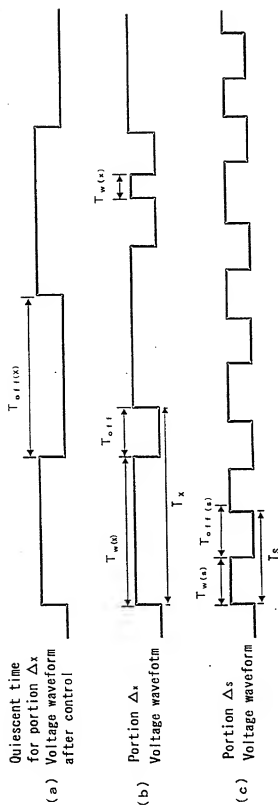


Fig. 11

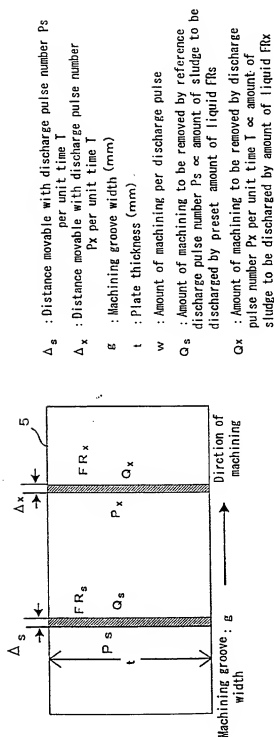


Fig. 12

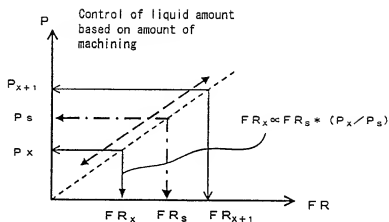


Fig. 13

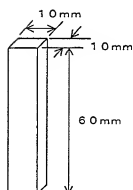


Fig. 14

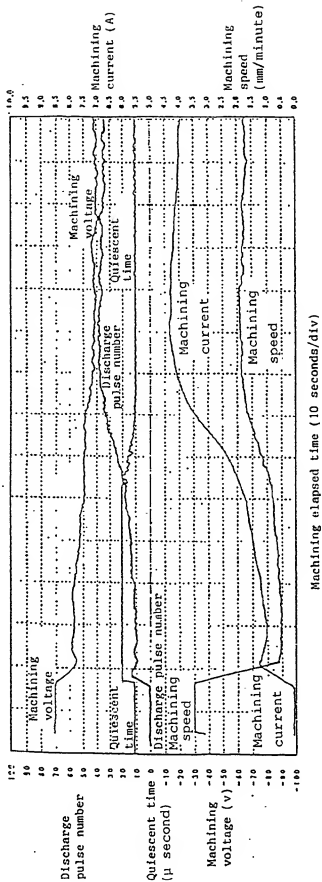


Fig. 15

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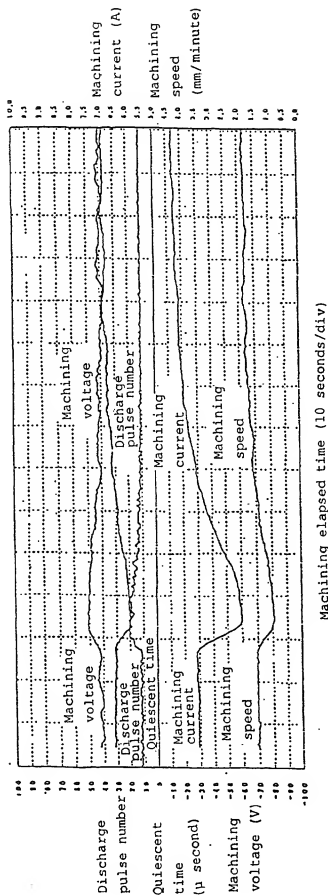


Fig. 16

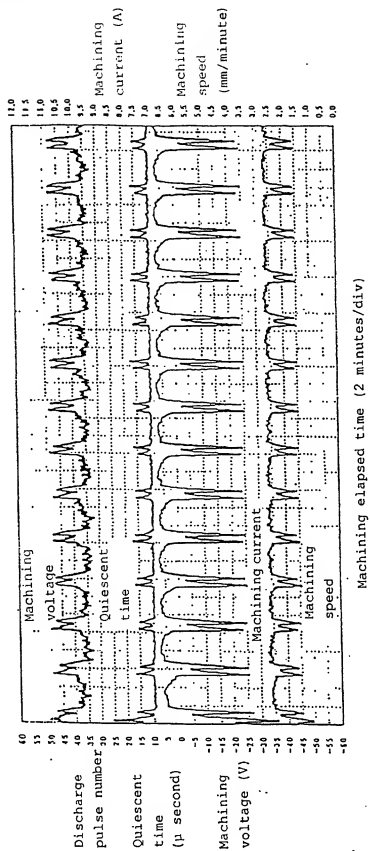
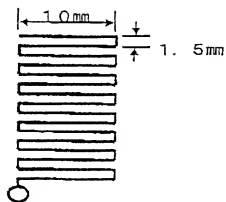


Fig. 17



Machining start

Fig. 18

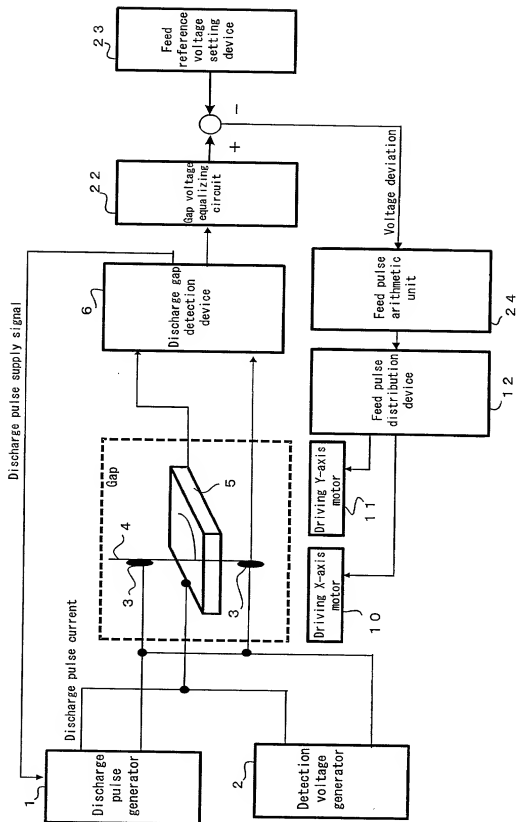


Fig. 19

